



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3163-3**Job Sheet 199566****Part No:** D3163-3**Job Qty:** 4 pcs**Part Name:** Plate*Small Qty- Spacedoor***Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/28/19**Job Tracking No:****Due Date:** 9/27/19**Created By:** Jennifer Renwick**Type:** SOLD**Description:** Order 13294**Note:** DWG D3116 REV.F IPP B 05.10.25 Remove Powder Coat KJ/RF IPP C**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		9/27/19	0.17	0.31	Waterjet - Flow	9/11/19	JRB
110	QC 2	4 pcs		9/27/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

**Container No:** S213017**Part:** D3163-3**Job No:** 199566**Serial No/Batch:** S213017**Revision:** F**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 08/11/19

Plex 8/28/19 1:44 PM Dart.Renwick.Jennifer

120 QC 8	4 pcs	9/27/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	JRB 9/11/19
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - 2 - B4B	4 pcs	9/27/19	0.00 0.40	Small Fab - 1 - B4B	DAS 58 SEP 17 2019 9-89
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	9/27/19	0.00 0.29	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	

Plex 8/28/19 1:44 PM Dart.Renwick.Jennifer

					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 QC 7	4 pcs	9/27/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
160 Packaging 3-1 - Stock - B4B	4 ✓ pcs	9/27/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	

DAS
40
SEP 13 2019
8:39

ST 484

Packaging 3 - 5 - B4B	
Packaging 3 - 6 - B4B	
Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B	
Packaging 3 - 9 - B4B	
Packaging 3 - 10 - B4B	
Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	
Packaging 3 - 22 - B4B	
Packaging 3 - 23 - B4B	
Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B	

170 QC 21 - SA 4 ✓ 9/27/19 0.00 0.00

pcs

QC 21 - SA - 21

ST 484

DAS

QC 21 - SA - 70

SEP 16 2019

70

QC 21 - SA - 53

9-89

Part Op 100 - 1-Cut as per Dwg D3163 Dwg Rev: F

Prog Rev: F 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - (Small Fab) 1- c'sink holes as per dwg 2- deburr

140 - HandFinish1 Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.032	2024-T3 .032 Sheet	1.2880 sf (.322 ea)	100-Waterjet - Flow - 1	5018261

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.032	1	164	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plate	0.098inches + 0.004 - 0.001	0.102 0.097	099 Diameter	
2	Plate	0.250inches + 0.005 - 0.001	0.255 0.249	252 Diameter	
3	Plate	1.050inches + 0.012 - 0.001	1.062 1.049	1.050 Diameter	
4	Plate	3.483inches ± 0.010	3.493 3.473		
5	Plate	1.063inches ± 0.010	1.073 1.053		
6	Plate	3.250inches ± 0.010	3.260 3.240		
7	Plate	6.500inches ± 0.010	6.510 6.490		
8	Plate	0.344inches ± 0.010	0.354 0.334		
9	Plate	0.250inches ± 0.010	0.260 0.240		
10	Plate	7.330inches ± 0.030	7.360 7.300		
11	Plate	0.032inches ± 0.010	0.042 0.022		

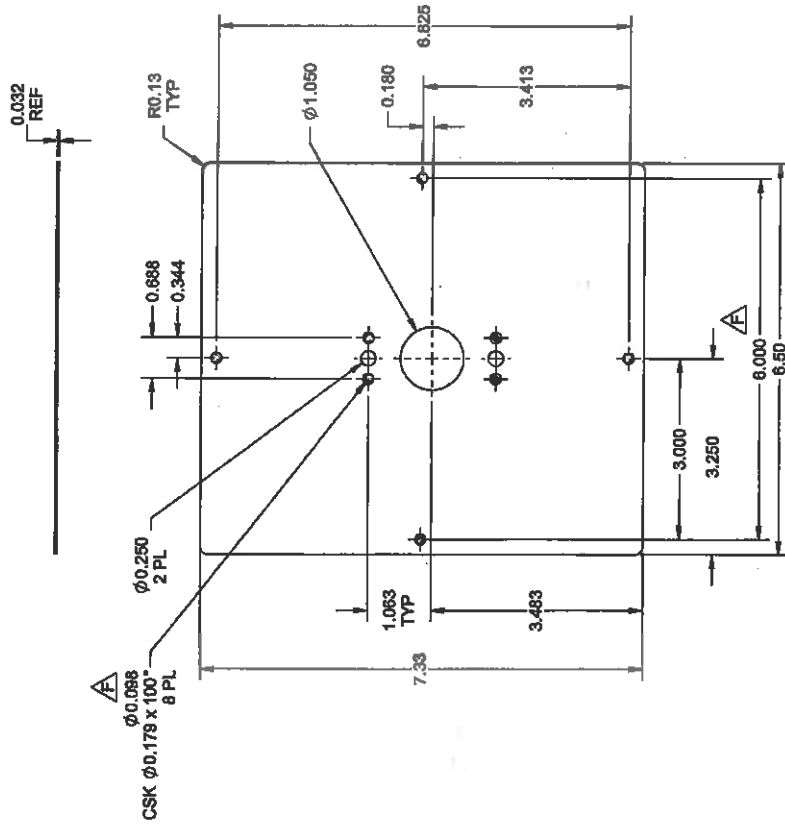
Plex 8/28/19 1:44 PM Dart.Renwick.Jennifer

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 199566



D3163-3 PLATE

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER QQ-A-250/4, REF DART SPEC. M2024T3S.032 OR 6061-T6 ALUMINUM SHEET 0.032 THICK PER QQ-A-250/11, REF DART SPEC. M6061T6S.032
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
 - 7) WEIGHT: 0.16 lbs

RELEASED
2019 MAY 07

APPROVED

DESIGN	RF	RF	DART AEROSPACE LTD
DRAWN	RF	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	VS	VS	DRAWING NO.
MFG. APPR.	DO	DO	D3163
APPROVED	VS	VS	SHEET 4 OF 4
DE APPR.	DS	DS	SCALE
DATE	18.01.30	18.01.30	PLATE

CONFORMITY TO DART AEROSPACE LTD
SPECIFICATIONS AND STANDARDS
THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD
AND IS NOT TO BE REPRODUCED OR USED IN ANY MANNER WITHOUT
THE WRITTEN PERMISSION OF DART AEROSPACE LTD